

BLUE

Date: Wednesday, 03/09/2008 10:28:57 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206L/L3/L4 HIGH GEAR SKID	
Job Number :	41733	Part Number :	D206642411BL	
Estimate Number :	10525	Drawing Number :	N/A - BLUE	
P.O. Number :		Project Number :	N/A	
This Issue :	03/09/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	L	
First Issue :	//	Type :	SKIDTUBES	
Previous Run :	41321	Material :		
Written By :		Due Date :	26/09/2008	Qty: 1 Um: Each
Checked & Approved By :	<i>JUD 08.9.03</i>			
Comment :	Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JLM Est Rev:L 07-12-04 ECN 1080p DD verified by:			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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u

include copy of D259421



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-411 CHG004

S 08/09/05

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	41733A	206 L HIGH GEAR SKIDTUBE
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Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE

1 x D206-642-441 Batch

B41733A

S 08/09/25 x1

4.0	D206648011	GHW Modification
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GHW Modification Kit

Batch:

B42215

ATTN: BLUE D2659 LUG

S 08/09/24

(1)

5.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

16 D2652

Bushing

40928

1 D206-642-441(REF)

C 8/9/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 41733

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2655

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2655 BLUE

Tow Ring B 37668

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

10 D2712

Set Screw 37765

8.0

D29321

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2932-1 BLUE

Saddle 41712

8/9/25

SP

9.0

D29331

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2933-1 BLUE

Saddle 41713

8/9/25

SP

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2934

Saddle Spacer 41132

8/9/25

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2935

Saddle Spacer 42262

28 08/09/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 41733

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29381

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2938-1 (BLUE)

Saddle 41714

8/9/25

50

13.0

D29391

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2939-1 (BLUE)

Saddle 38944

8/9/25

14.0

D2968043

Tow Ring



D3407-043



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2968-043 (BLUE)

Tow Ring 42212

8/9/25

80

15.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN3-41A

Bolt M108673

8/9/25

16.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 AN4-5A

Bolt M106605

8/9/25

1425 1x D3456-1

B 40288

2x D3457-1

B 41016

1x M521043-4

B M109148

8/9/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 41733

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt

M107534

[Signature]

18.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN5-11A

Bolt

M108928

[Signature]

19.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

AN5-12A

Batch:

M104885

[Signature]

20.0

AN513A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch

M108167

[Signature]

21.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10

Washer

M109059

[Signature]

22.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

Description Batch

1 AN960JD1016

Washer

M10519

[Signature] 8/23 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 41733

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Qty Part Number

Description Batch

25 AN960JD416

Washer

M108161

24.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number

Description Batch

8 AN960JD516

Washer

M108672

25.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

Description Batch

1 AN970-4

Washer

M108928

26.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number

Description Batch

8 MS21042L3

Nut (or -3)

M108701

27.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

M107499

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

800/09/05

B41733A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:28:57 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 41733

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-411

Location: _____

PPP Rev: _____

Rev D

8808/caf/5 (X)

30.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

D08/09/26

Job Completion



MF 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday 03/09/2008 10:28:57 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-HAR001 Dart Helicopters Services Drawing Name : 206L/L3/L4 HIGH GEAR SKID
 Job Number : 41733
 Estimate Number : 10525
 P.O. Number :
 This Issue : 03/09/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D206642411BL
 First Issue : / / Type : SKIDTUBES Drawing Number : N/A - BLUE
 Previous Run : 41321 Drawing Revision : L
 Written By : Due Date : 26/09/2008 Qty: 1 Um: Each
 Checked & Approved By : JUD 08.9.03
 Comment : Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JLM
 Est Rev:L 07-12-04 ECN 1080p DD verified by:

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JUD 08.9.16



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-411 CHG004

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 41733A 206 L HIGH GEAR SKIDTUBE



Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE

1 x D206-642-441 Batch _____

4.0 D206648011 GHW Modification



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GHW Modification Kit

Batch: _____

ATTN: BLUE D2659 LUG

5.0 D2652 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2652 Bushing _____

1 D206-642-441(REF) _____

BLUE 642411

Dart Aerospace Ltd.

Date: Wednesday, 03/09/2008 10:29:25 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
 Job Number : 41733A
 Estimate Number : 10522
 P.O. Number :
 This Issue : 03/09/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D206642441
 First Issue : / / Type : SKIDTUBES Drawing Number : D2650 REV E
 Previous Run : 41321A Project Number : N/A
 Material :
 Due Date : 26/09/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 08.9.03
 Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
 Est Rev: I 08-05-01 add QC3 DD verified by: EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

2.0	D2620	Skidtube, 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2620	Bent Tube 3" OD	41820

RT 08-09-09

3.0	D2647	Cap
-----	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2647	Fwd Cap	25475 BE

08/09/09

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod

M107877 / M108708

BE 08/09/09

4-Grind weld flush to cap on top surface only.

BE 08/09/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:29:25 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 41733A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube

BE 08/09/11

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

BE 08/09/11

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BE 08/09/11

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 08/09/11 X 8-9-11

7.0

D26547

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

40249 SL 8-9-12

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

SL 8-9-12

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 8-9-12 Time: 1:30

Finish Date: 8/9/12 Time: 7:30 am

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 41733A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

108801

Sikaflex expiry date:

8-10-1

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/09/15 FL

10.0

D2649

Cross Bolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

40830

SL 8-9-14

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M107877

BE 08/09/15

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

H 8-9-16

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

H 8-9-17

12.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

B39599

① H 8-9-17

13.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

M109068

② H 8-9-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 41733A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

M 152515

② M 3-9-17

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

① M 3-9-17

16.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/02/18 (C)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/02/18 (C)

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M. H.

08/04/18

(X)

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B106729

-SPRAY PAINT DELFLEET BLUE

B105918

-CLEAR DELFLEET

B109333

ml 08 09 19

(1)

(P)

20.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

0809-23 (1)

21.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

(3x) 13411671 (3x) 13411641 ml 08-09-20 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/09/26

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-09-22	19.0	Primer was visible on the edges of the ridge, along the tube. R. C: the Primer was lighter than the base.	<i>[Signature]</i>	- Scuff & re-paint per QSI 005	25 08 -09 -22	<i>[Signature]</i> 08-09-23	<i>[Signature]</i>	<i>[Signature]</i> 08-09-23

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 41733A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D265615

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe 1334596

JH

23.0

D265623

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe 1334597

JH

24.0

D265637

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe 1341634

~~1341634~~
1341634

JH

25.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad 1341842

JH

26.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts 1105819

or (see QSI 017)

JH

08-09-24

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:29:25 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 41733A

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

27.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

M1105793

JH

28.0	MS27039108	Screw
------	------------	-------



Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

62 MS27039-1-08

Screw

M1109061

JH

29.0	D26511	Plug
------	--------	------



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

(BLUE)

Plugs

B34882

JH

30.0	D26513	O-Ring
------	--------	--------



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

B38742

JH

31.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

M1105426

JH

08-09-24

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:29:25 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 41733A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

M107862

HL

33.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2646

BLUE

Aft Cap

B35011

HL

34.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M1108443

Sikaflex expiry date:

08/11

Black

✓ 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

✓ 3-Install MS27039-4-06 Screw as per DEO 9153

✓ 4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

M1108443

Sikaflex expiry date:

08/11

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M107892

HL 08-05-24 (X)

FL 08/09/24 @

35.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/09/25 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:29:25 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 41733A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP-41733

JS 08/09/25 @

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/09/26 (1)

Job Completion



12 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTRELEASED
16 04 17 #

DESIGN <i>11</i>	DRAWN BY <i>P</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

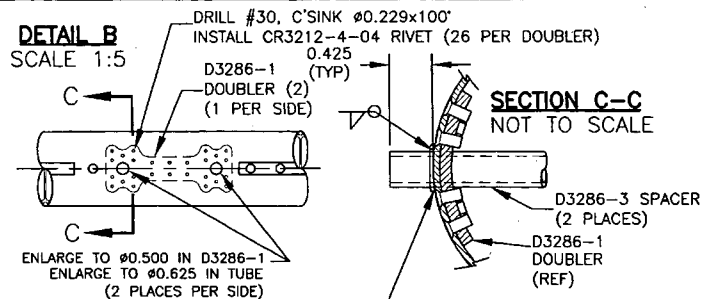
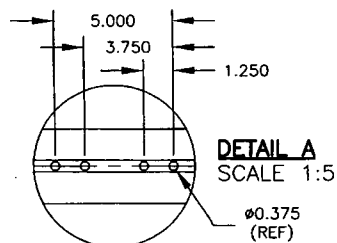
Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES

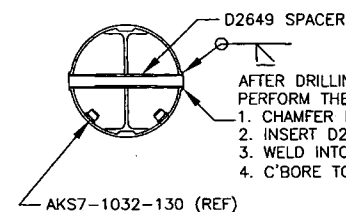
- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SECTION C-C NOT TO SCALE

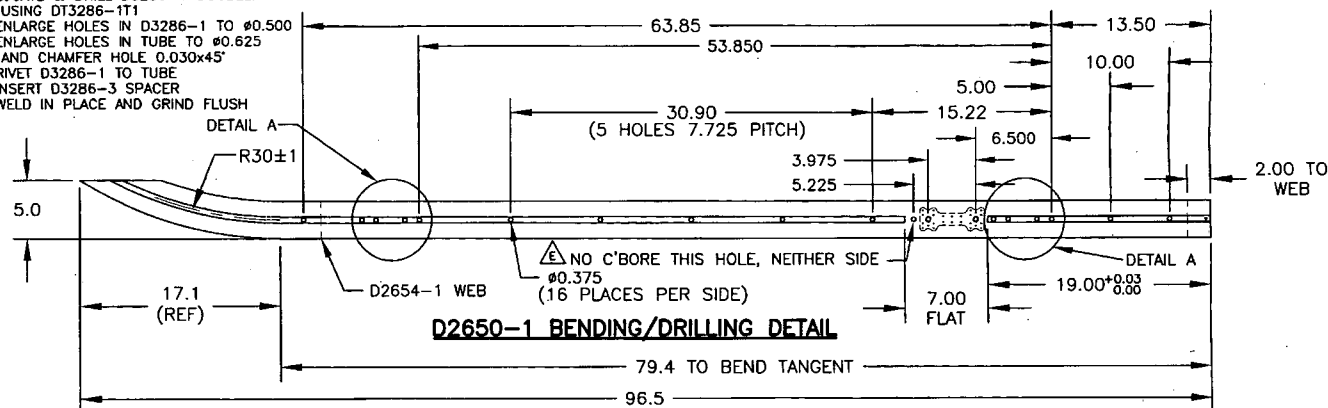
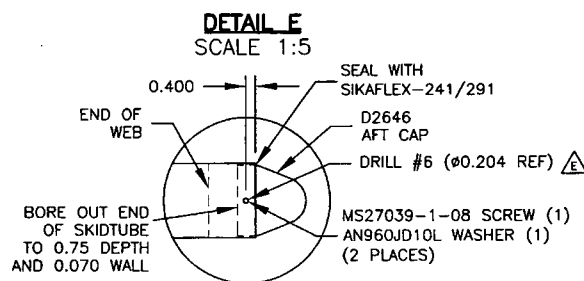


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313 X 0.75 DEEP

RELEASED

06.04.17

- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO 0.500
 4. ENLARGE HOLES IN TUBE TO 0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH



DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

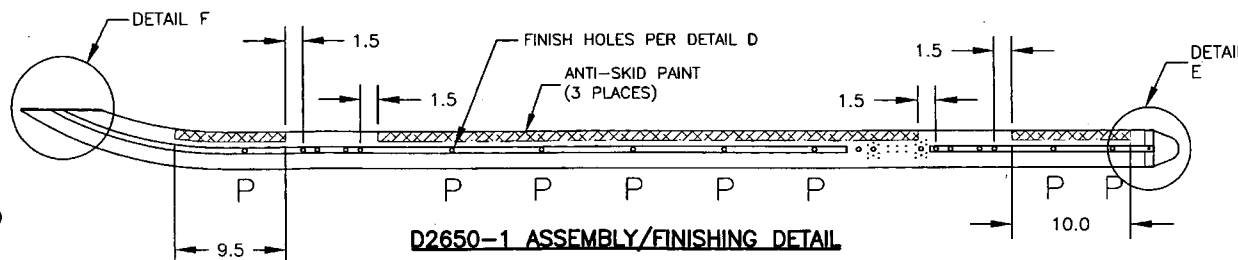
NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

- CCR2645S3-3 RIVET (2 PLACES)
MS27039-4-06 SCREW (1)
AN960JD416 WASHER (1)
CR3212-4-03 RIVET (2 PLACES)
D2680-041 NUTPLATE (1)
D2647 CAP (1)

ORIENTATION OF D2680-041

REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.

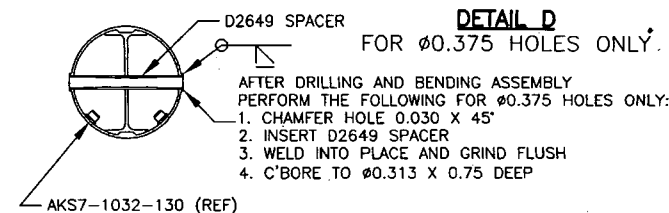
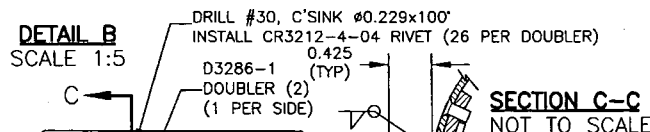
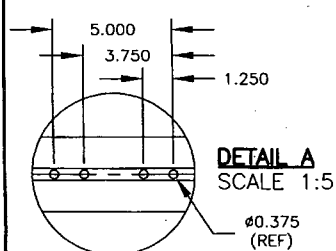
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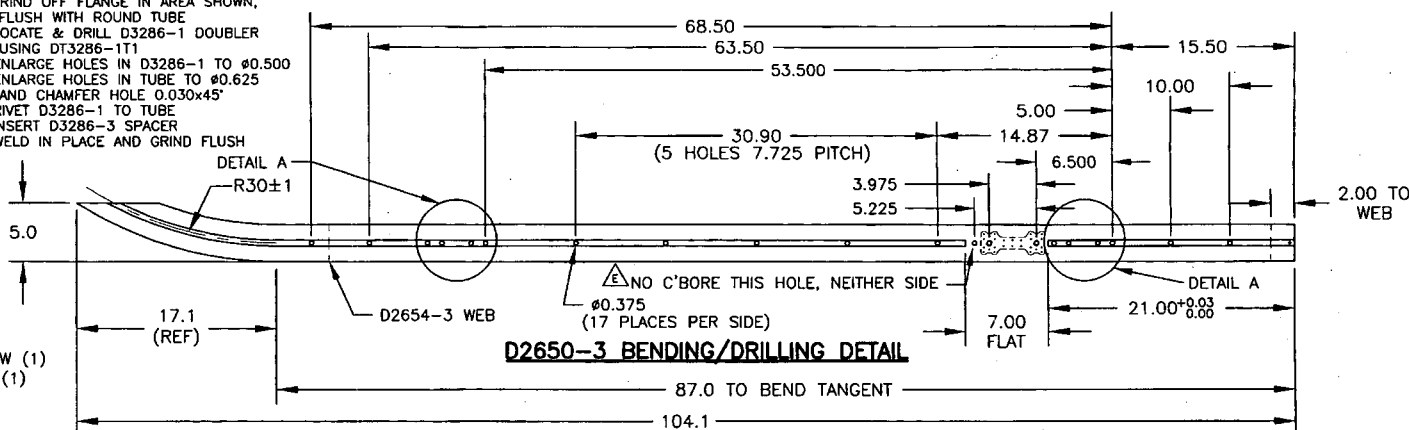
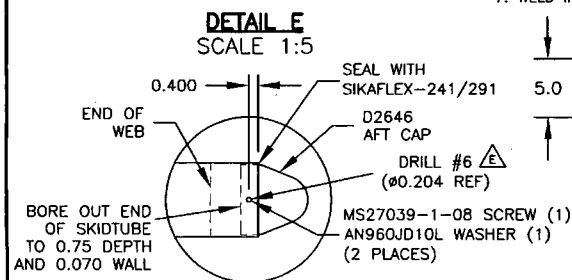
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DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO.	REV. E
DATE		D2650	SHEET 2 OF 5
06.03.30		TITLE	SCALE
		SKIDTUBE	1:10



RELEASED
06.01.17

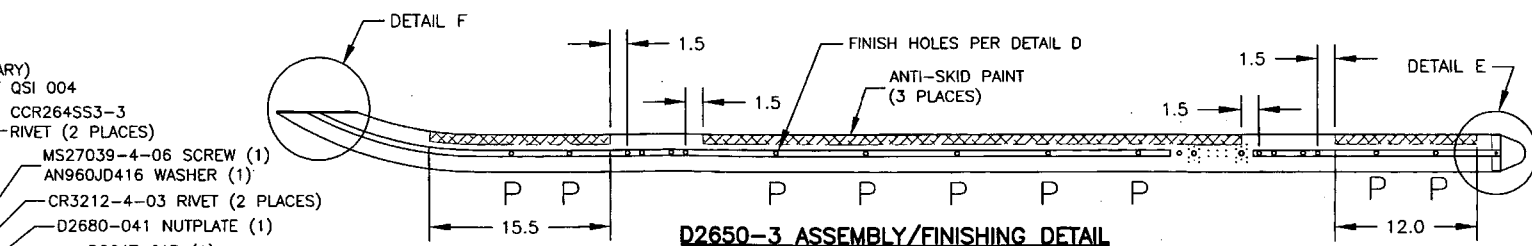
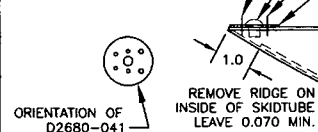
- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING D3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH



DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



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DESIGN	UP	DRAWN BY	IP	DART	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	AL	DRAWING NO.	D2650
DATE	06.03.30	TITLE	SKIDTUBE	REV. E	SHEET 3 OF 5
				SCALE	1:10

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NO. 117334

SCALE

1-10

NO. 175

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 41313 A
Part number: D206 642 441
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Diwel Date of Test Coupon 08-08-26
Welder Barclay Elliott Date of Test Coupon 08-08-26

The above named individual is qualified in accordance with AWS D17.1.2001 to weld